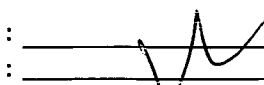


Date: Wednesday, 04/06/2008 3:07:17 PM  
 User: Julie Lecocq

## Process Sheet

OK

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SEAT BACK PAN (AFT FACING LH/RH)
Job Number	: 39704		
Estimate Number	: 13363		
P.O. Number	:	Part Number	: D37743
This Issue	: 04/06/2008 S.O. No. :	Drawing Number	: D3774 PROTOTYPE
Prsht Rev.	: NC	Project Number	: 00196
First Issue	: / / Type : THERMOFORMING	Drawing Revision	: A 08.06.06
Previous Run	:	Material	:
Written By	: 	Due Date	: 10/06/2008 Qty: 2 Um: Each
Checked & Approved By	:		
Comment	: Est. REV:A New Issue 08.06.04 DL		

Additional Product

PROTOTYPE

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

Set up machine program D3774-3

Set up clamping frame as per folio

DL 08.06.05

2.0

MLEXS125F6002904

GE PLASTICS LEXAN SHEET



Comment: Qty.: 10.6670 sf(s)/Unit Total: 21.3340 sf(s)

GE PLASTICS LEXAN SHEET

M 105330. DL 08.06.05

3.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks

DL 08.06.05 x2

4.0

THERMOFORMING

THERMOFORMING MACHINE



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D32811 and Folio FTA 011

Dwg. Rev. A

Folio Rev. A

DL 08.06.05 x2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT BACK PAN (AFT FACING LH/RH)

Job Number: 39704

Part Number: D37743

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



X2

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DL 08.06.05

6.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



X2

Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

DL 08.06.06

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



X2

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1) Check Surface finish for undesired marks, voids, dimples etc.

DL 08.06.06

2) Check dimensions to ensure conformity to drawing tolerances.

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING  
APPROVAL

08.06.06 (2)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

00196 A Testing

08.06.06 (2)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.06.06 Perotype

Job Completion



h 08.06.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Thermo

## PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D412-769Job #: 00196Date: 08.04.23Product Name: Aft Facing SeatRequested By: CPDesign Manager Approval: MAP

Quantity	Part Number	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
2 <i>WV</i>	D3774-1	Seat Bottom, LH, <del>RH</del>	08.04.23	Y	08.05.22	per dwg D3774	
<del>1</del>	<del>D3774-2</del>	<del>Seat Bottom, RH</del>	<del>08.04.23</del>	<del>Y</del>	<del>08.05.22</del>	<del>per dwg D3774</del> NA <i>de</i>	
2 <i>WV</i>	D3774-3	<del>Seat Bottom, LH, RH</del> <i>BACK</i>	08.04.23	Y	08.05.22	per dwg D3774	
<del>1</del>	<del>D3774-4</del>	<del>Seat Bottom, RH</del>	<del>08.04.23</del>	<del>Y</del>	<del>08.05.22</del>	<del>per dwg D3774</del> NA <i>de</i>	

DART AEROSPACE LTD	WORK ORDER:	39704
Description: Seat Back (Aft Facing)	Part Number:	D37743
Inspection Dwg: D3774 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

(Step 4) Thermoforming  
Visual Inspection Sign-off

Description	Initials
Acceptable shape definition	DP
Free of visual flaws (bumps, cracks, voids, etc.)	DP

### (Step 6) Trimming FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing D 3774 Rev. A and record below

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
33.8" 33.9	.100"	33.9	✓		TAP	
23.6" 23.5	.100"	23.6	✓		"	
1.8"	.100"	1.8	✓		"	
1.1"	.100"	1.1	✓		"	

Measured by: <u>DP</u>	Audited by: <u>[Signature]</u>	Prototype Approval: <u>[Signature]</u>
Date: <u>08-06-06</u>	Date: <u>08-06-06</u>	Date: <u>08-06-06</u>

Rev	Date	Change	Revised by	Approved
		New Issue		



Attn: CENTAL

**GE Polymershapes**

1250 OLD INNES RD. 519 OTTAWA, ONT. K1B 5L3  
TEL: 613 745 7043 FAX: 613 745 8163

## CERTIFICATE OF COMPLIANCE

SOLD TO: DART AEROSPACE

DATE: 8/17/2007

YOUR PURCHASE ORDER : PO00004161

OUR SHIPPER NO: 078178

LINE ITEM # .1

QUANTITY: 81

DESCRIPTION: F60029 LEXAN GY3778 125 X 48 X 96

THESE PARTS WERE MANUFACTURED IN ACCORDANCE WITH: FAR 25. 853

THIS IS TO CERTIFY THAT THE MATERIAL FINISHES AND FUNCTIONAL REQUIREMENTS OF THE ABOVE LISTED PARTS ARE IN ACCORDANCE WITH THE REFERENCE PROCUREMENT SPECIFICATIONS, CONTROL DRAWINGS OR PARTS DESIGNATION AND LATEST REVISIONS AS REFERENCED ON THE SUBJECT PURCHASE ORDER.

AUTHORIZED REPRESENTATIVE SIGNATURE

JON CALDWELL  
BRANCH MANAGER

# Receiving Report

Date: 07/08/16 Batch No: M105330  
 Supplier: G.E. Polymershapes Dart P/O: 4161

Packing Slip: Yes ☒ No ☐ Release Note Attached: Yes ☐ No ☒ N/A ☐  
 Invoice: Yes ☐ No ☒ Waybill Attached: Yes ☒ No ☐  
 Receipt: Cash ☐ Cr ☒ Shipment Complete: Yes ☒ No ☐ N/A ☐  
 QC6 Inspection Go No/12 N/A ☒  
 Work Order                      N/A ☒

## Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12                     

Production/Admin:

Date: 07/08/16  
 Received/Costing: RIP 5911  
 Initial: GG

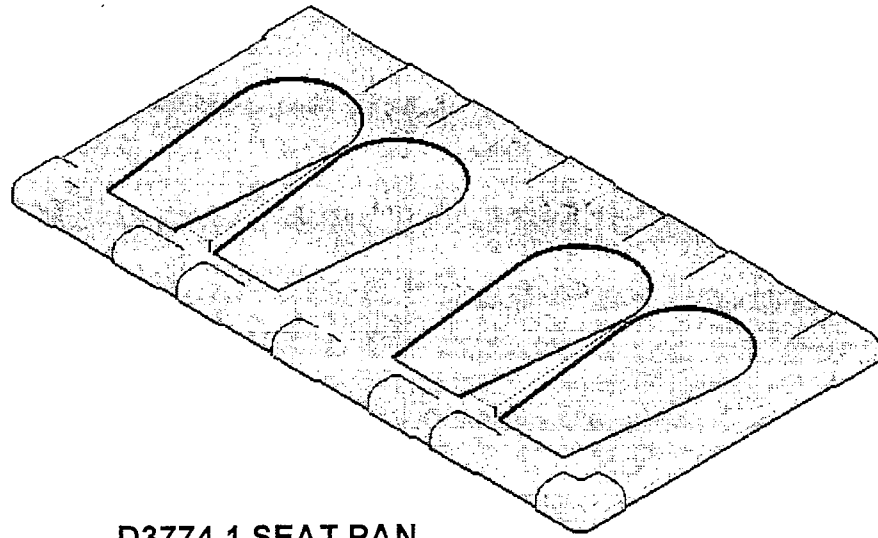
Location                     

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

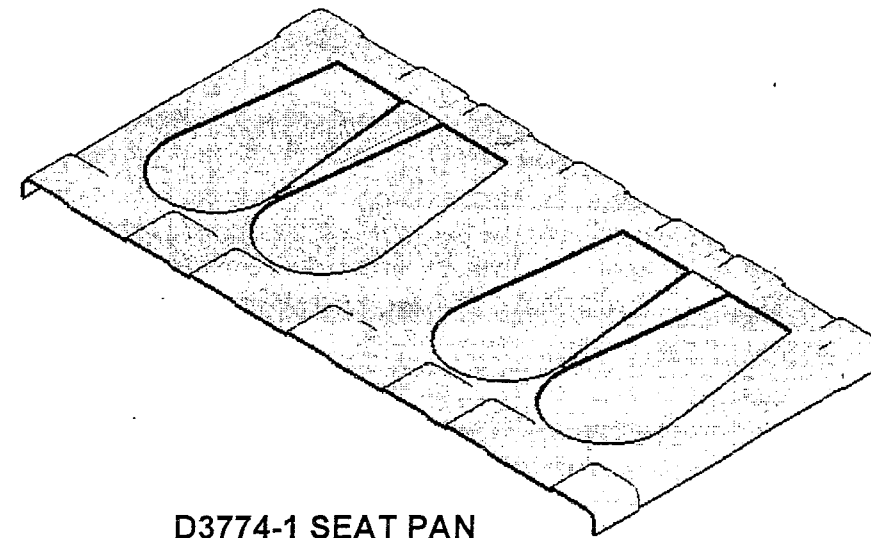
\*\* PLEASE NOTE: IF YOU WOULD LIKE TO HAVE FUTURE INVOICES FAXED OR E-MAILED TO YOU PLEASE MAIL OR FAX A COPY OF THIS INVOICE TO OUR BRAMPTON LOCATION WITH YOUR INFORMATION\*\*  
 THANK YOU  
 EMAIL/FAX INFO                     

PLEASE Remit To: GE Polymershapes 9150 Airport Road Brampton ON L6S 6G1 Tel: 905-789-3111 Fax: 905-789-3152  
 NO GOODS TO BE RETURNED WITHOUT APPROVAL FROM US. ALL DISCREPANCIES MUST BE REPORTED WITHIN 3 DAYS.



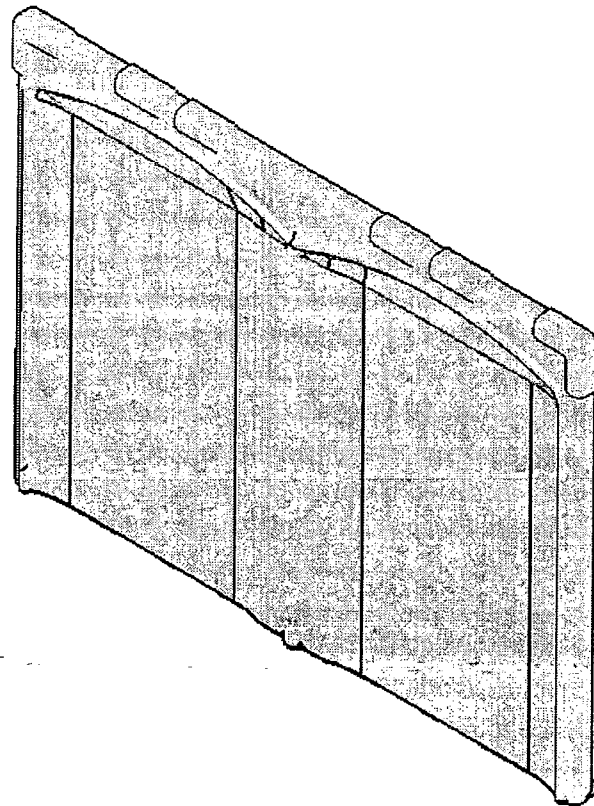


**D3774-1 SEAT PAN**

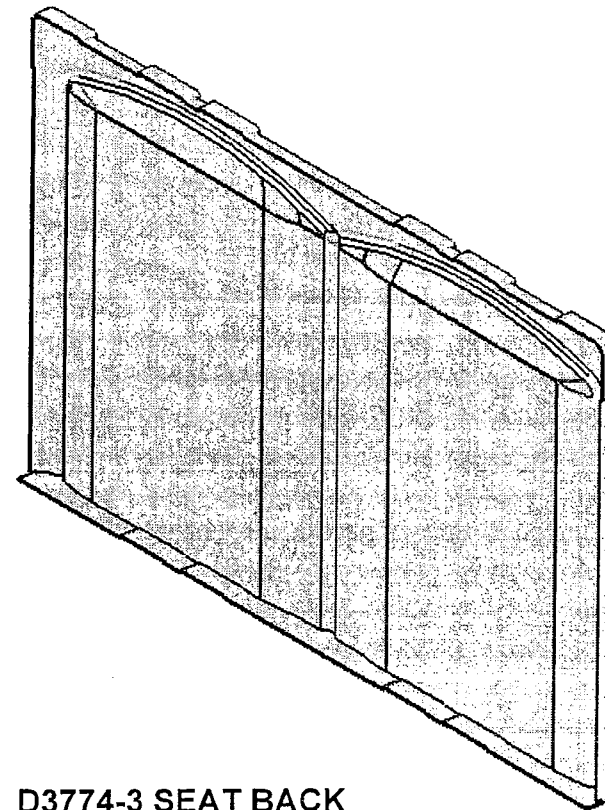


**D3774-1 SEAT PAN**  
(REVERSE VIEW)

**PROTOTYPE**  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING  
*AJS 08.06.04*

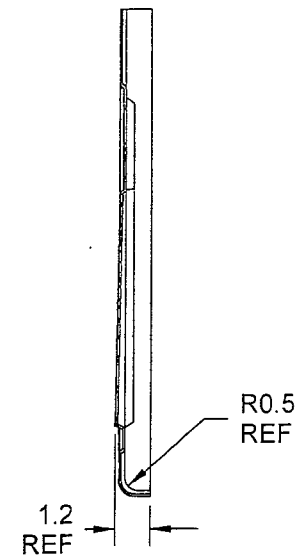
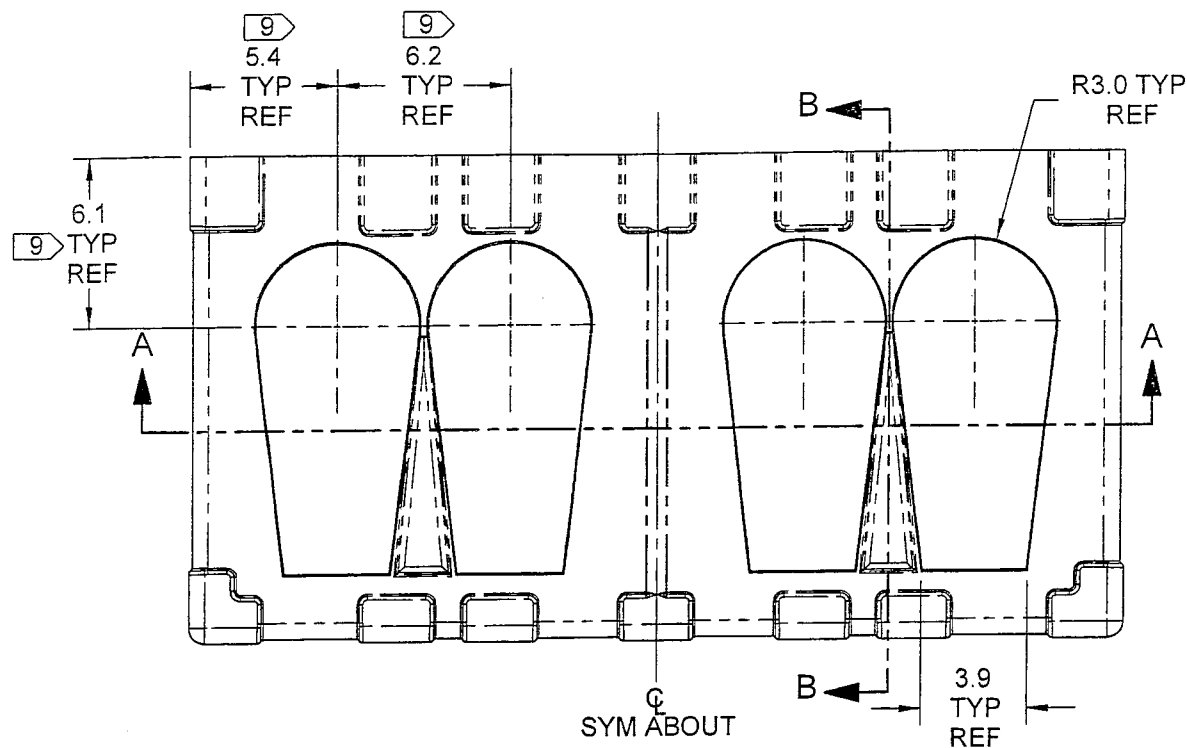


**D3774-3 SEAT BACK**

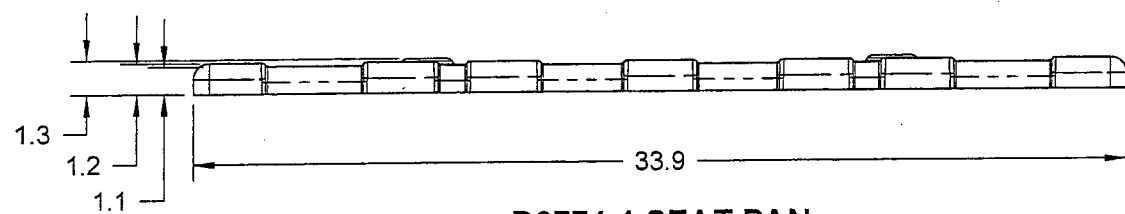


**D3774-3 SEAT BACK**  
(REVERSE VIEW)

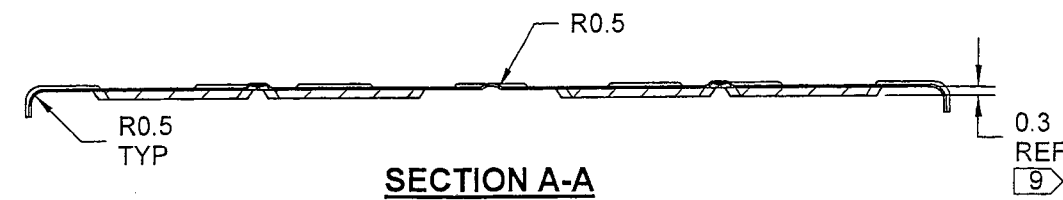
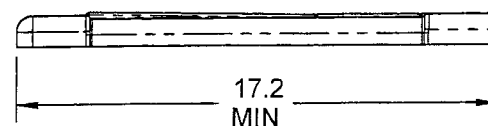
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REV.	DESCRIPTION	BY	DATE
DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D3774</b>	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>SEAT</b>	NTS
DATE	08.06.04	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



**SECTION B-B**



**D3774-1 SEAT PAN**



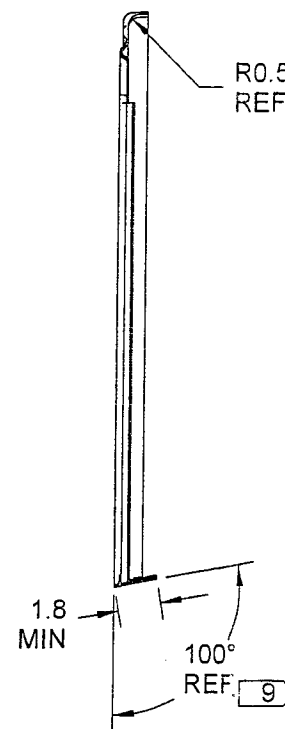
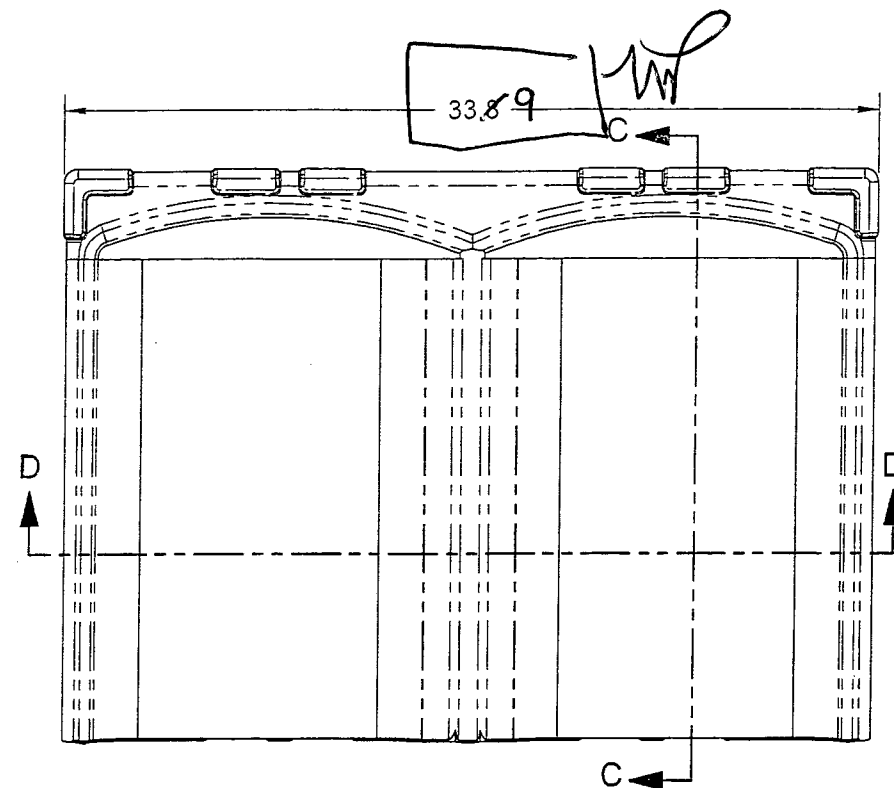
**SECTION A-A**

**PROTOTYPE**  
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DATA TO ENGINEERING  
1155 08.06.04

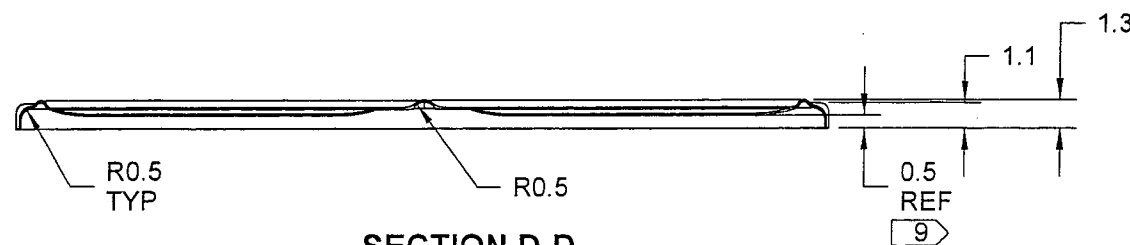
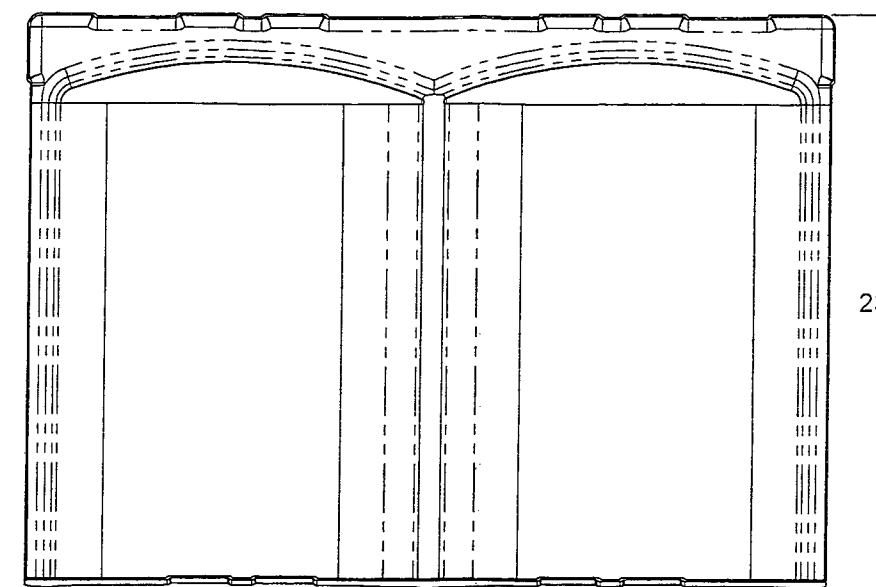
**NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125" THICK TEXTURED SIDE UP (REF. DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3774-1" USING VIBRATING STYLUS
- 7) WEIGHT: D3774-1, 3.0 lbs
- 8) PART TO BE PRODUCED FROM MOLD DT9022.
- 9) OVERALL DIMENSIONS GIVEN ONLY FOR FURTHER INFORMATION REFER TO MOLD DT9022 OR SOLIDWORKS GRAPHICS MODEL.
- 10) MINIMUM MATERIAL THICKNESS AFTER FORMING 0.06.

DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3774	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SEAT	NTS
DATE	08.06.04	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



**SECTION C-C**



**SECTION D-D**

**PROTOTYPE**  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING  
AJS 08.06.04

**NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125" THICK TEXTURED SIDE UP (REF. DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI'018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3774-3" USING VIBRATING STYLUS
- 7) WEIGHT: D3774-2, 3.5 lbs
- 8) PART TO BE PRODUCED FROM MOLD DT9023.
- 9) OVERALL DIMENSIONS GIVEN ONLY FOR FURTHER INFORMATION REFER TO MOLD DT9023, OR SOLIDWORKS GRAPHICS MODEL.
- 10) MINIMUM MATERIAL THICKNESS AFTER FORMING 0.06.

DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3774	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SEAT	NTS
DATE	08.06.04	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	